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October 30, 2009 1:03:11 PM

Item ID:

D2724-042

Revision ID: C

Item Name:

206L Step Assembly

Start Date:

29/10/2009

Start Qty: 4.00

Required Date: 09/11/2009

QC:

Accept

Setup Start

Stop



Req'd Qty: 4.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: ___

Date 09-10-30

)Tooling: Date:

SPC (Y/N):

0.00

0.00

0.00

Date: Date:

Run

Stop

Reject

Start



Sequence ID/ **Work Center ID**

Operation Description

Revision Nbr

Set Up/ **Run Hours**

Draw Number

SAD 09-10-30

Draw Rev.

Plan

Code

Accept Qty

Reject Qty

Insp. Number Stamp

Draw Nbr D2724

Rev C

100

Large Fab

Large Fab

Large Fab

Memo

Cut D2724-2 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

110

Large Fab Large Fab

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using $\,$ Jig DT8898 $\,$

followed by Jig

A/R AL ROD Batch: <u>M///3//</u>

m111494

Grind end cap welds flush

C

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Item ID:

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Revision ID:

206L Step Assembly **Item Name:**

Start Date:

29/10/2009

Req'd Qty: 4.00

Required Date: 09/11/2009

QC:

Start Oty: 4.00

Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

120 -

Quality Control

Operation Description

OC9- Inspect visual per OSI004- Fusion Welds

Memo

Memo

Memo

Date:

0.00

0.00

Draw (Number

Draw Plan Rev.

Accept Code Qty

Reject Qty

Reject Insp. Stamp Number

130

Quality Control

QC5- Inspect part completeness to step on W/O

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

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Item ID:

D2724-042

Accept



Setup Start



Stop

Revision ID:

C **Item Name:** 206L Step Assembly

Start Date:

29/10/2009

Start Qty: 4.00

Req'd Qty: 4.00 **Required Date:** 09/11/2009

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Draw

Rev.

Date:

Run

Stop

Start



Sequence ID/ Work Center ID

150

Quality Control

Operation **Description**

QC3- Inspect Part Finish

Memo

Set Up/

SPC (Y/N):

Run Hours

0.00

SAO 09-11-05

Number

Draw

Accept

Plan

Code

Qty

Reject Qty

Reject Insp. Number Stamp

160



Large Fab

Large Fab

Inspect for foreign object per QSI 024

0.00

0.00

09.11.05

Weld Remainig end cap as per Dwg D2724 using Jig DT8898 followed by Jig

A/R AL ROD Batch: *M*///3//

Grind end plate flush.

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Item ID:

D2724-042

Accept

Setup Start



Revision ID:

C **Item Name:**

206L Step Assembly

Start Date:

29/10/2009

Start Oty: 4.00

Required Date: 09/11/2009

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Memo

Memo

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:_ Run

Start

Stop

Stop



Sequence ID/ **Work Center ID**

170

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/ **Run Hours**

0.00

0.00

Draw Number

Draw Plan Rev. Code Accept Qty

Reject **Qty**

PO-11-PO

Reject Insp. Number Stamp

180

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

190

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Il orlalor

HandFinish

0.00

C

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Item ID:

D2724-042

Accept

Setup Start



Stop

Item Name:

206L Step Assembly

Start Date:

Revision ID:

29/10/2009

Start Qty: 4.00

Required Date: 09/11/2009

Reg'd Qty: 4.00

Cust Item ID: Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Draw

Rev.

Plan

Code

Run

Reject

Qty

Accept

Qty

Start

Stop

Reject



Number Stamp

Insp.

Sequence ID/ Work Center ID

205

SprayPaint

Spray Painting

Operation Description Set Up/ **Run Hours**

0.00

0.00

Memo PRIME - GREY 110918

SPARY APINT DELFLEEAT BLUE 113171

CLEAR DELFLEET | 10896

215

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Bt 09-11-18

220

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch___

M112623

Memo

Bf 09-11-18 (4)

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Item ID:

D2724-042

Accept

Setup Start



Revision ID: **Item Name:**

C

206L Step Assembly

Stop

Start Date:

29/10/2009

Start Oty: 4.00

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Start Run

Stop



Required Date: 09/11/2009

QC:

Date:_____

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw Rev.

Accept Qty

Reject

Insp.

230

Sequence ID/

Work Center ID

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

Number

Draw

Code

Plan

Qty

Reject Stamp Number

240

Packaging Packaging

Identify as per dwg & Stock Location:____

0.00

0.00

PNP 53267/09/11/19(9)

250

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- 11-19 A 09-11-19

Picklist Print

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Work Order ID: 53270

D2724-042RevC Parent Item:

Parent Item Name: 206L Step Assembly

· Comments:



Start Date: 29/10/2009

Required Date: 09/11/2009

Start Oty: 4.00

Required Qty: 4.00

Comments:								2	tart Qty: 4.00	. к	equirea Qiy: 4.0	,0
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2734RevC		Manufactured	No			120	Each	65.0000	8.0000	Man.	1.04	
				<u>Warehou</u>	<u>ise</u>	Loc	<u>Oty</u>	Loc Code				
				Loca	<u>tion</u>							
				Main Wa	rehouse							
				ST			65					
					43535		2		_	11.+4		
D3458-1RevA		Manufactured	No	-	48110	120	63 Each	19.0000	8.0000	-/-//		
		Manufactured	110				·	17.0000		12 og	11.04	
				Warehou	<u>ise</u>	<u>Loc</u>	Oty	Loc Code				
				Loca	<u>tion</u>							
				Main Wa	rehouse							
				ST			19			8		
D2450 2D 4		3.5			51239	100	19 Earl	12 0000	0.0000	_8		
D3458-3RevA Step Mounting Plate	NIN 111 III 111 III III III 111	Manufactured	No			120	Each	13.0000	8.0000	<u> Il 09</u>	.11.04	
				<u>Warehou</u> <u>Loca</u>		<u>Loc</u>	Oty	Loc Code				
				Main Wa	rehouse							
				ST	53409		13			3		
					51240		13		_			

Picklist Print

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Work Order ID: 53270

ork Order ID: 3327

D2724-042RevC

Parent Item Name:

206L Step Assembly

Comments:

Parent Item:



Start Date: 29/10/2009

Required Date: 09/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D2622-120CRevC1		Manufactured	No			100	Each	147.9200	4.0000			



Step Extrusion

<u>Warehouse</u>	Loc Oty	Loc Code	
Location			
Main Warehouse			
WA	147.92		
48612	38.92		e.f
52026	109		

